

HIP AND SIP Welding Scope

2013 TAR

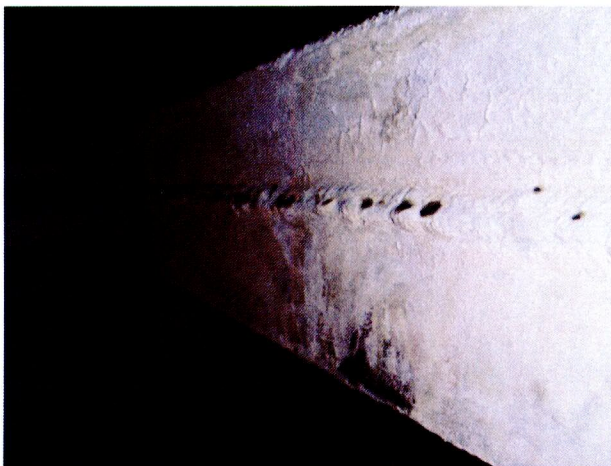
-Bottom Plenum CIP

-Clean wet sulfates between exchangers bottoms. (VIP)



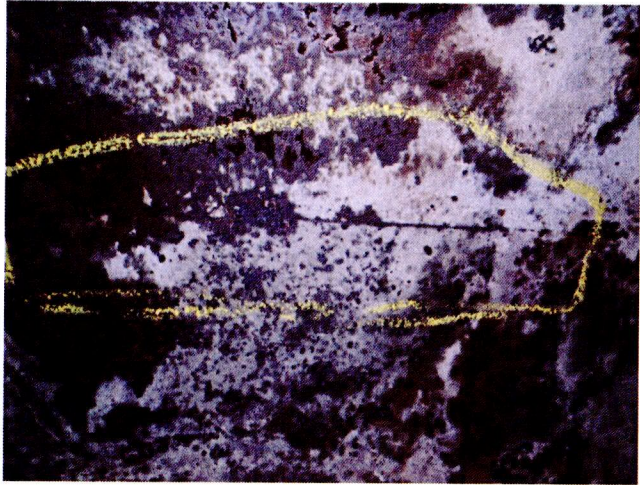
- Grind out existing weld and reweld. (VIP)

Install overlay plate. Tie to walls on each end and flanges ~1" from edge. Bevel plate and use 3 passes to ensure strength



TOP Plenum

-Dye Check the Crack and check externally for penetrant. (ACCUREN)



-UT bulge area (Accuren)



North Horizontal CIP

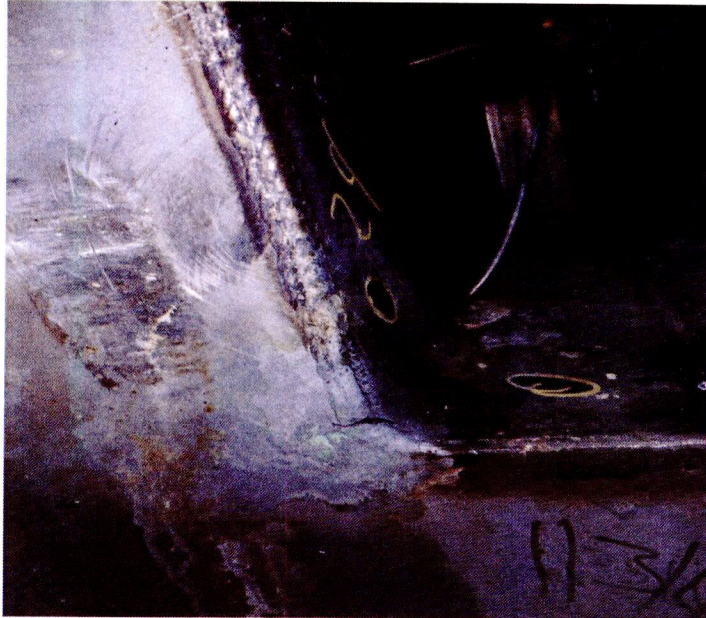
-Weld Plenum hole from inside (VIP)



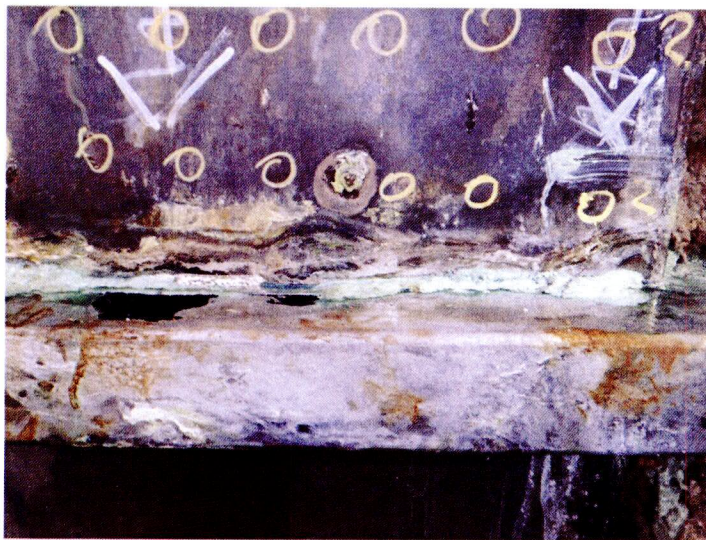
-Weld exchanger hole from outside. (Performance)



-Weld corner crack from outside. Grind out and reweld. . (Performance)



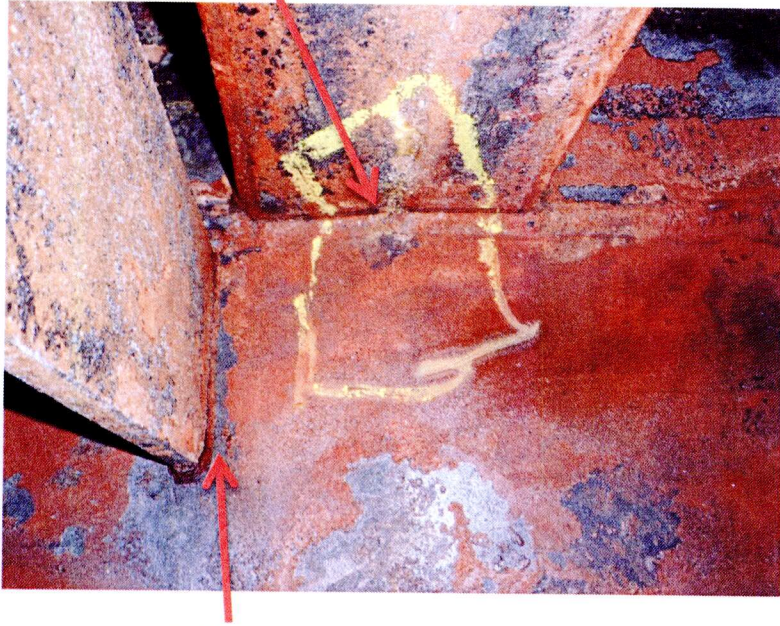
-Cut out box tubing and Scab patch over low area. . (Performance)



1410

HIP South Horizontal

-Weld new leak from inside. (VIP)

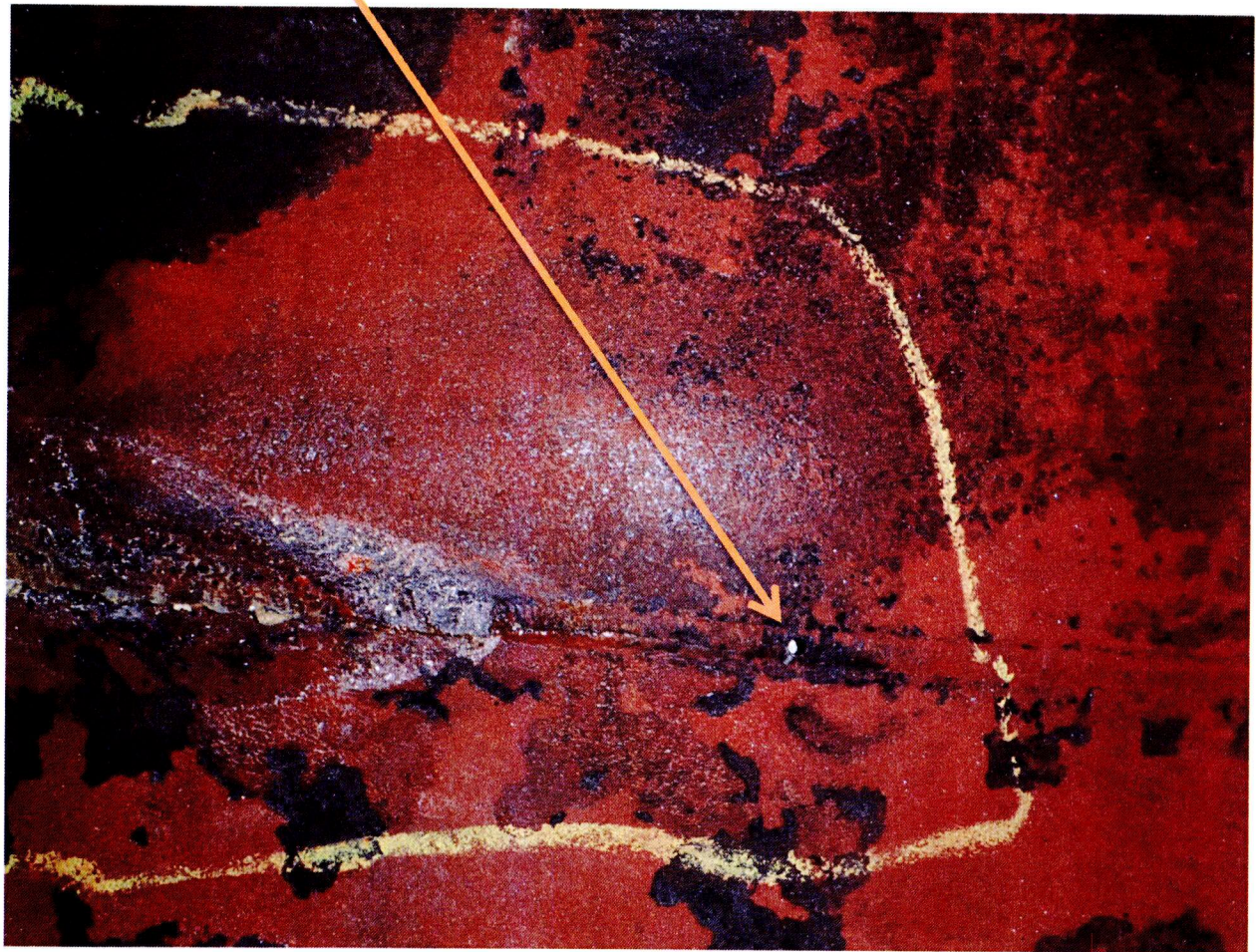


- Weld ends of stiffener plates to duct. Bevel ends and weld w/ 3 passes Aprox 6 stiffeners. (VIP)

-Weld corner crack from exterior. (Performance)



-Fill in drilled hole on weld seam. This hole was drilled to stop the crack in the weld seam from extending further.



IVY ALBERES

MIQA INSPECTOR

October 14, 2013

1412